

# Work Order ID 117318

June-16-14 10:54:19 AM

**\*117318\***

Page 1

Item ID: D4806-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Clevis  
 Start Date: 6/16/14 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 6/16/14 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference: PART MARKING

Approvals: Process Plan: W Date: 1406-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4806	REV A								

105 0.00

**\*105\***

Purchasing Memo 0.00 CZ 14/06/17

Purchasing

Memo

PULL FROM STK:

2 X D4806-1 B112026

SEND TO P & L PRINTING FOR PART MARKING

PO 24622

115 Receive & Inspect for Damage & Mat'l Certs 0.00

**\*115\***

Packaging Memo 0.00 Pc 14/6/18 (2)

Packaging

125 QC6- Inspect dimensions to drawing 0.00

**\*125\***

QC Memo 0.00 2

Quality Control

DAS

27

9-89

14/6/20

Work Order ID 117318

\*117318\*

Page 2

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Item ID: D4806-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Clevis  
 Start Date: 6/16/14 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 6/16/14 Req'd Qty: 2.00 \*2\* Customer:  
 Reference: PART MARKING

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <i>STD</i>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

*2X* *14-6-20* DAS 26 9-89

*ML5* *14-06-23*

*14-6-20*

# Picklist Print

June-16-14 10:54:19 AM

Page 1

Work Order ID: 117318

**\*117318\***

Parent Item: D4806-1

**\*D4806-1\***

Parent Item Name: Clevis

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 2.00

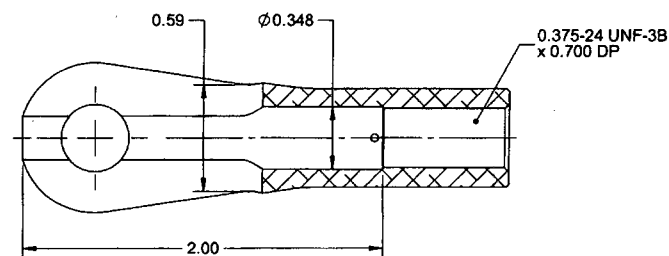
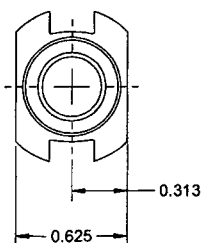
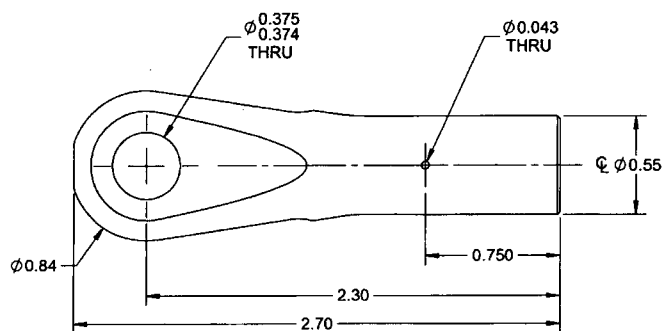
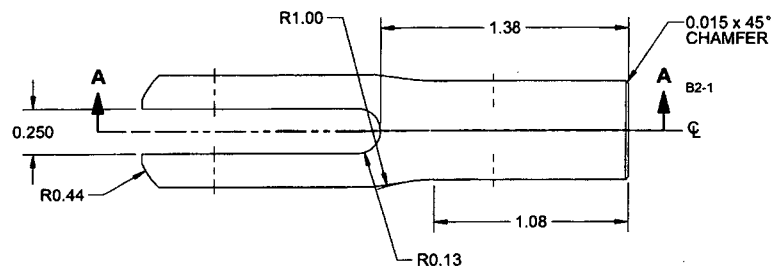
Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 14-01-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4806-1		Manufactured	No				Each	0.0000		2			
<b>*D4806-1*</b>									<b>**</b>				
Clevis													

ST123

3/2026  
6/14/2014



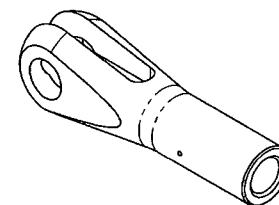
**SECTION A-A** D5-1

**D4806-1 CLEVIS**

**NOTES:**

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION  
PER AMS 5643/ASTM A564  
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.13 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 117318 MLJ  
14-06-16



APPROVED	A NEW ISSUE		RF	13.09.16
	REV.	DESCRIPTION		BY DATE
	DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	DC	DRAWING NO.	REV. A
	MFG. APPR.	JLM	<b>D4806</b>	SHEET 1 OF 2
APPROVED		HS	TITLE	SCALE
DE APPR.		DS	<b>END FITTING</b>	NTS
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19226 Airport Road  
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Tel. 613-931-1241  
Fax 613-931-2560  
plprinting@bellnet.ca

# PACKING SLIP

**SOLD TO**

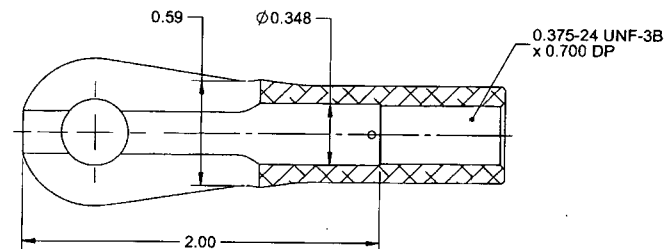
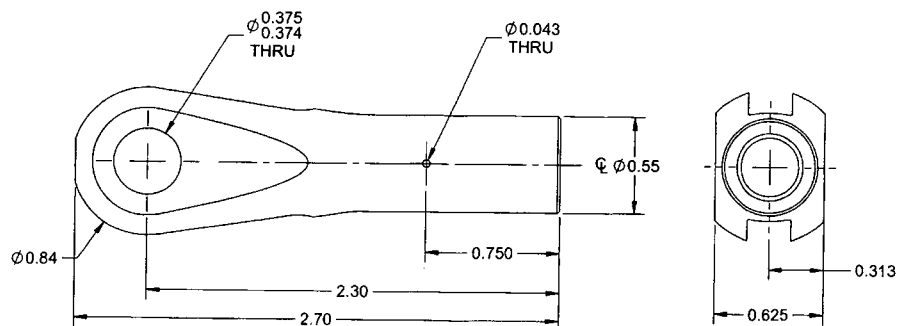
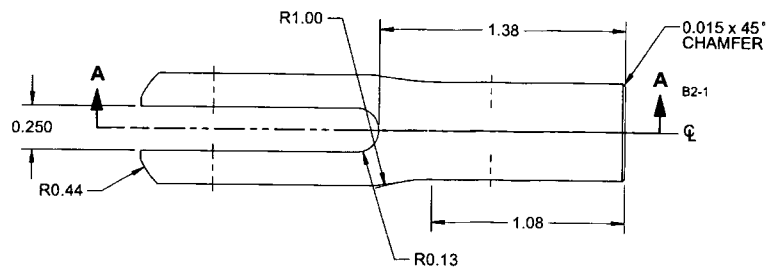
DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**SHIPPED TO**

DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**P.O NUMBER** PO24622

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4880-042 LEG ASSEMBLY	1	ALL ITEMS HAVE BEEN LASER MARKED
D4881-041 LEG ASSEMBLY	1	
D4881-042 LEG ASSEMBLY	1	
D4882-041 LEG ASSEMBLY	2	
D4880-041 LEG ASSEMBLY	1	
D4803-1 STRUT	1	
D4871-3 END FITTING EYE	11	
D4866-2 STRUT	2	
D4882-1 STRUT	3	
D4866-1 STRUT	2	
D4928-1 STRUT	4	
D4807-041 SUPPORT ASSEMBLY	2	
D4878-1 STRUT	1	
D4867-1 STRUT	4	
D4868-1 STRUT	4	
D4884-1 END FITTING EYE	8	
D4884-3 END FITTING EYE	5	
D4801-1 STRUT	1	
D4804-1 STRUT	2	
D4806-1 CLEVIS	2	
D4806-3 STUD	8	
D4879-1 STRUT	2	



SECTION A-A D5-1

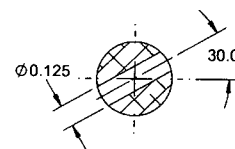
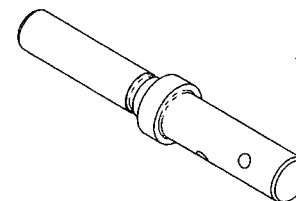
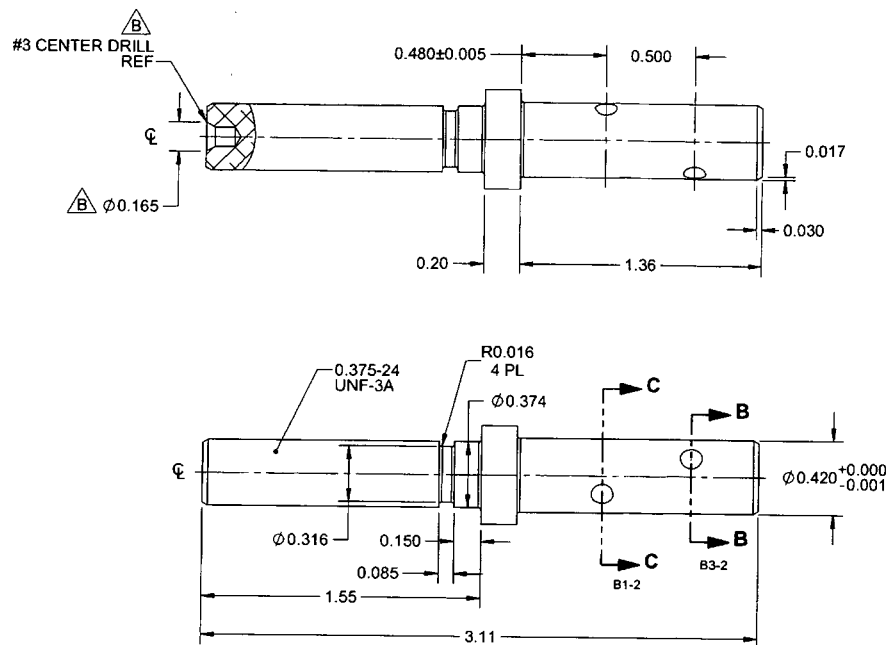
**D4806-1 CLEVIS**

**NOTES:**

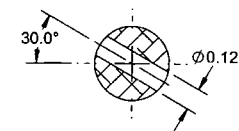
- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION  
PER AMS 5643/ASTM A564  
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.13 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

**RELEASED**  
2014-06-16

B	ADD CENTER DRILL TO -3 (ZN D8-2)	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION		DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	<b>D4806</b>	SHEET 1 OF 1
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DE APPR.	DS	<b>END FITTING</b>	NTS
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SECTION B-B C5-2



SECTION C-C C6-2

# D4806-3 STUD

**RELEASED**  
2014-06-16

## NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION PER AMS 5643/ASTM A564 DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.11 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	<b>D4806</b>	SHEET 2 OF 2
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